

**Work Order ID 67088**

Tuesday, March 08, 2011 10:29:00 AM

Page 1

Item ID: D2594-1

Revision ID:

Item Name: Plug, 205 Skidtube

Start Date: 3/9/2011 Start Qty: 50.00

Required Date: 3/14/2011 Req'd Qty: 50.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan: *MF*Date: *11-03-08*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2594

Rev C

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max.

*11/3/14**50*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*11/3/14**50*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*B.A 11/03/14**50*

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Item ID: D2594-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug, 205 Skidtube

Start Date: 3/9/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 3/14/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

50 6 11/6/15

135



Powdercoat

Powder Coating

Drab Green(Ref:4.3.5.11)per QSI005 4.3 (Alum)

0.00

MIDH476.

Memo

START: 8:50  
QENT. 8:30  
FINISH: 9:20.

50 6 11-3-16

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

50 6 11/3/16

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Item ID: D2594-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug, 205 Skidtube

Start Date: 3/9/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 3/14/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: FR-A

0.00



Packaging

Memo

0.00

Packaging

50611/03/16

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/17CL 11/03/16

# Picklist Print

Tuesday, March 08, 2011 10:28:56 AM

Page 1

Work Order ID: 67088

Parent Item: D2594-1

Parent Item Name: Plug, 205 Skidtube


Start Date: 3/9/2011

Required Date: 3/14/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP D 02.08.22 Make in Cobra KJ  
IPP E 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No			110	f	34.5000	0.0521	2.742105			
													
6061-T6 Round Bar .625"													

Location

Loc Qty

Loc Code

MAT

24

116963

24

MAT012

10.5

112697

10.5

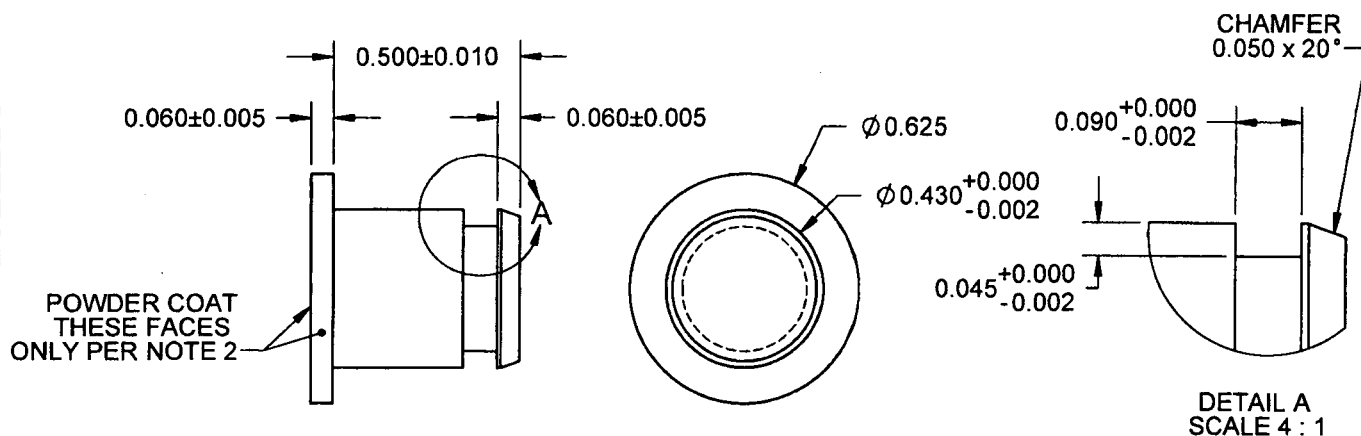
SA 11/3/14

2924



DESIGN #	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. <b>D2594</b>	REV. C SHEET 1 OF 1
DATE <b>06.11.20</b>	TITLE <b>PLUG</b> SCALE 2:1		
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED  
06.11.28



**D2594-1 PLUG**

**D2594-1 PLUG NOTES:**

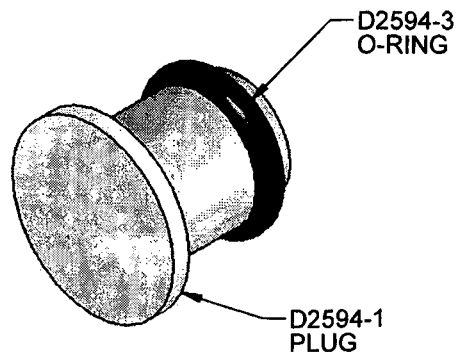
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

**D2594-3 O-RING NOTES:**

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



**D2594 PLUG ASSEMBLY**

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